

Ship 2704

SP1.7

Work Order ID 57994 - 1

April 21, 2010 11:50:11 AM



Item ID: D3400-1

Revision ID:

Item Name: Main Body

Start Date: 4/21/10

Required Date: 4/26/10

Reference:

Start Qty: 10.00

Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3400	Rev A

105



Packaging

Packaging

Memo

PULL FROM STOCK:
10 X D3400-1 B22561

0.00

0.00

10004.21

①

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

RE-MACHINE PER DRWG D3400 REV.A
DOWEL PIN HOLES MISSING

0.00

0.00

10.04.26

①

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

10.04.26

①

Work Order ID 57994

April 21, 2010 11:50:11 AM

Page 2

Item ID: D3400-1

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Start Date: 4/21/10

Required Date: 4/26/10

Reference:

Accept



Setup Start



Stop



Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

J-F-S 10/04/26 (1)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

SAND LIGHTLY

PLA

150



Powdercoat

Powder Coating

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

Memo

0.00

RE-POWDER COAT RED
PER QSI005

Mask all holes START TIME:

OVEN

TEMPERATURE:

FINISH TIME:

u 10-04-26

Work Order ID 57994

April 21, 2010 11:50:12 AM



Page 3

Item ID: D3400-1

Revision ID:

Item Name: Main Body

Start Date: 4/21/10

Start Qty: 10.00

Required Date: 4/26/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3-Inspect Part Finish

0.00

Memo

0.00

N/A

B57804

GA

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

RE-IDENTIFY USING NEW B/N

8/5 10/04/24

8/5 10/04/26

①

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/27

W 10.04.27



Picklist Print

April 21, 2010 11:50:10 AM

Page 1

Work Order ID: 57994

Parent Item: D3400-1

Parent Item Name: Main Body

Comments: IPP A 05.02.24 New issue KJ/JLM

Start Date: 4/21/10

Required Date: 4/26/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3400-1		Manufactured	No				Each	10.0000	10.0000			



Main Body



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST487

10

22561

10

10

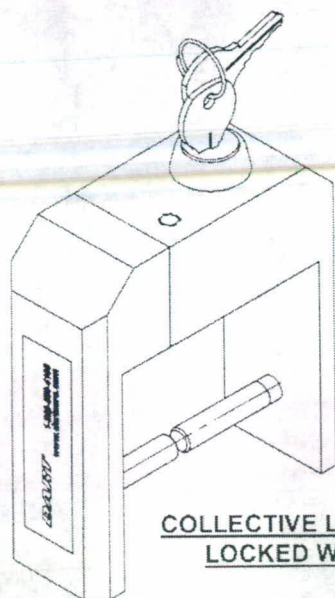
W00421



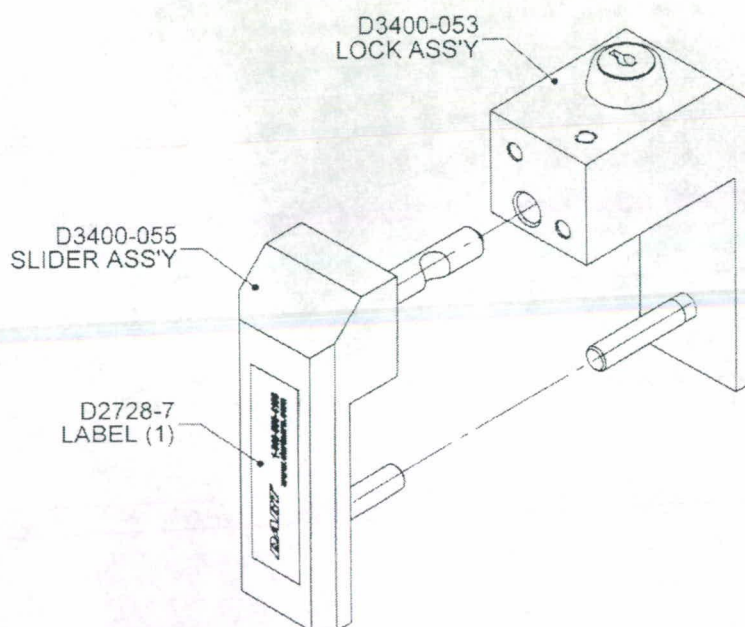
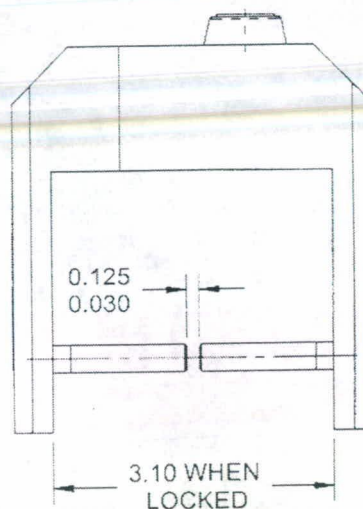
FIRST ARTICLE INSPECTION CHECKLIST



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 1 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.02.23	NEW ISSUE	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3400-051 AS355 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

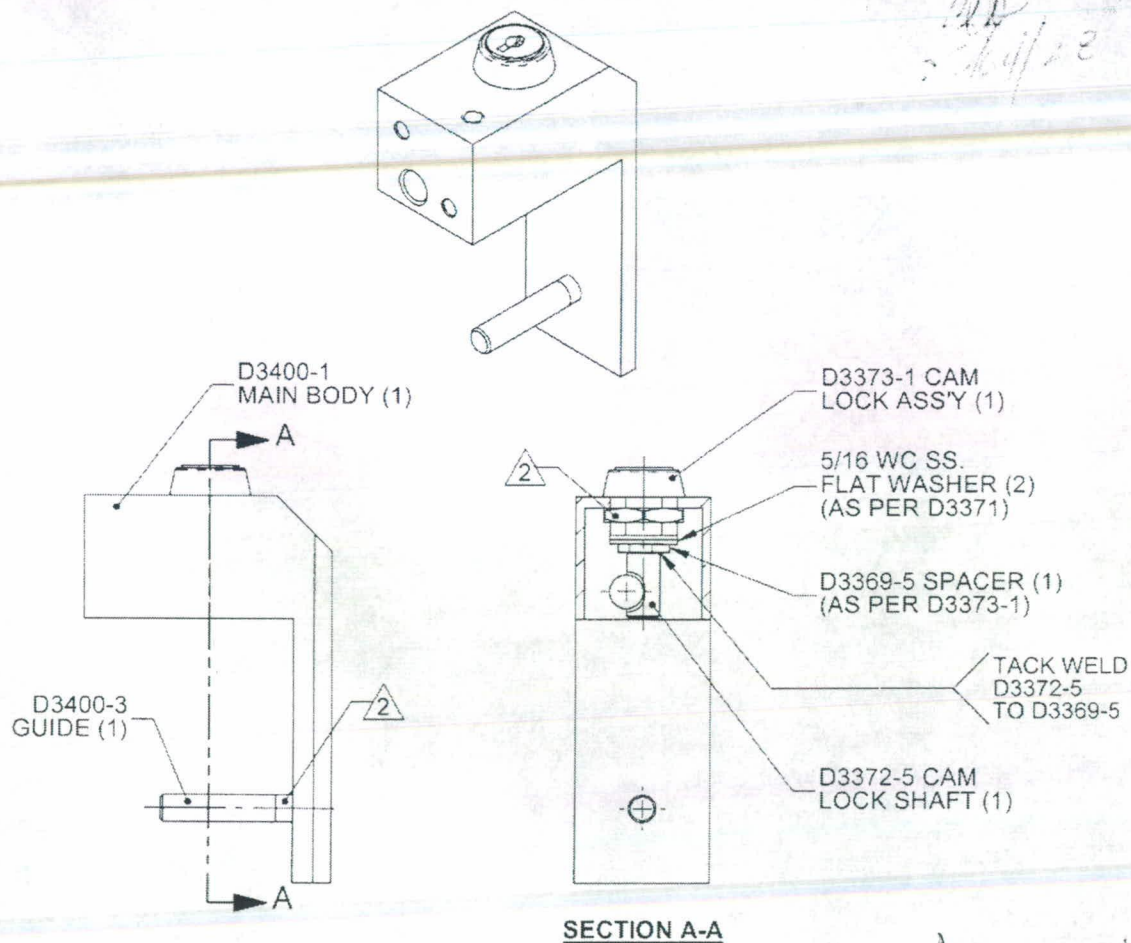
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CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 2 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3400-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

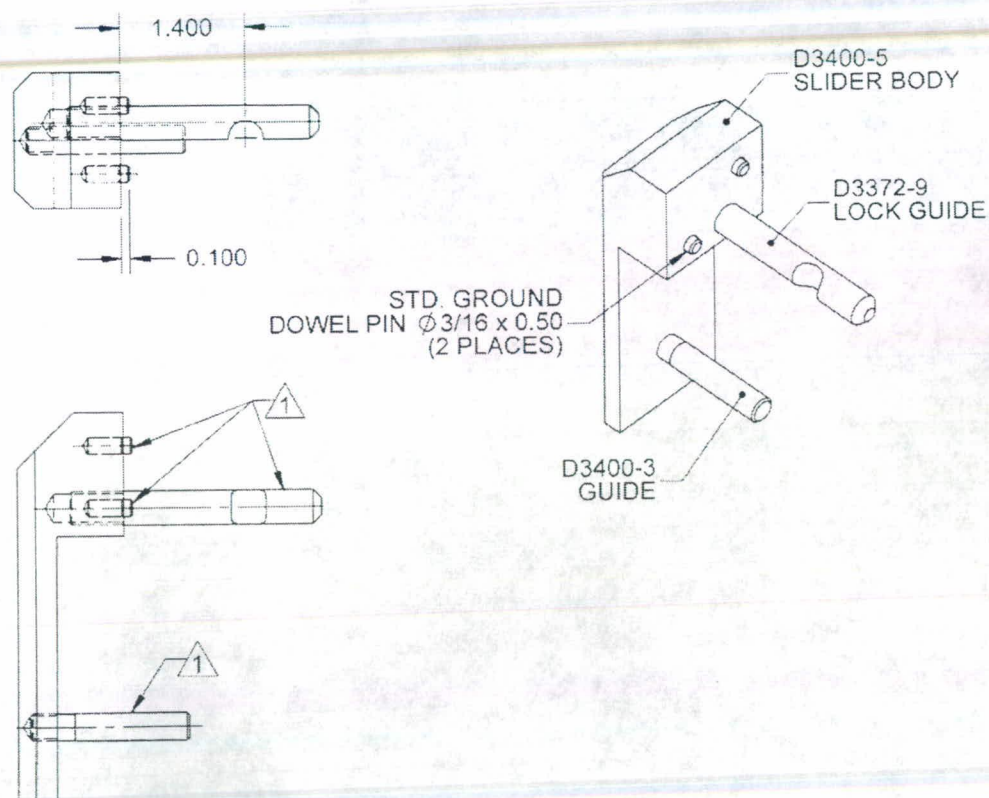
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3400-055 SLIDER ASS'Y

NOTES:

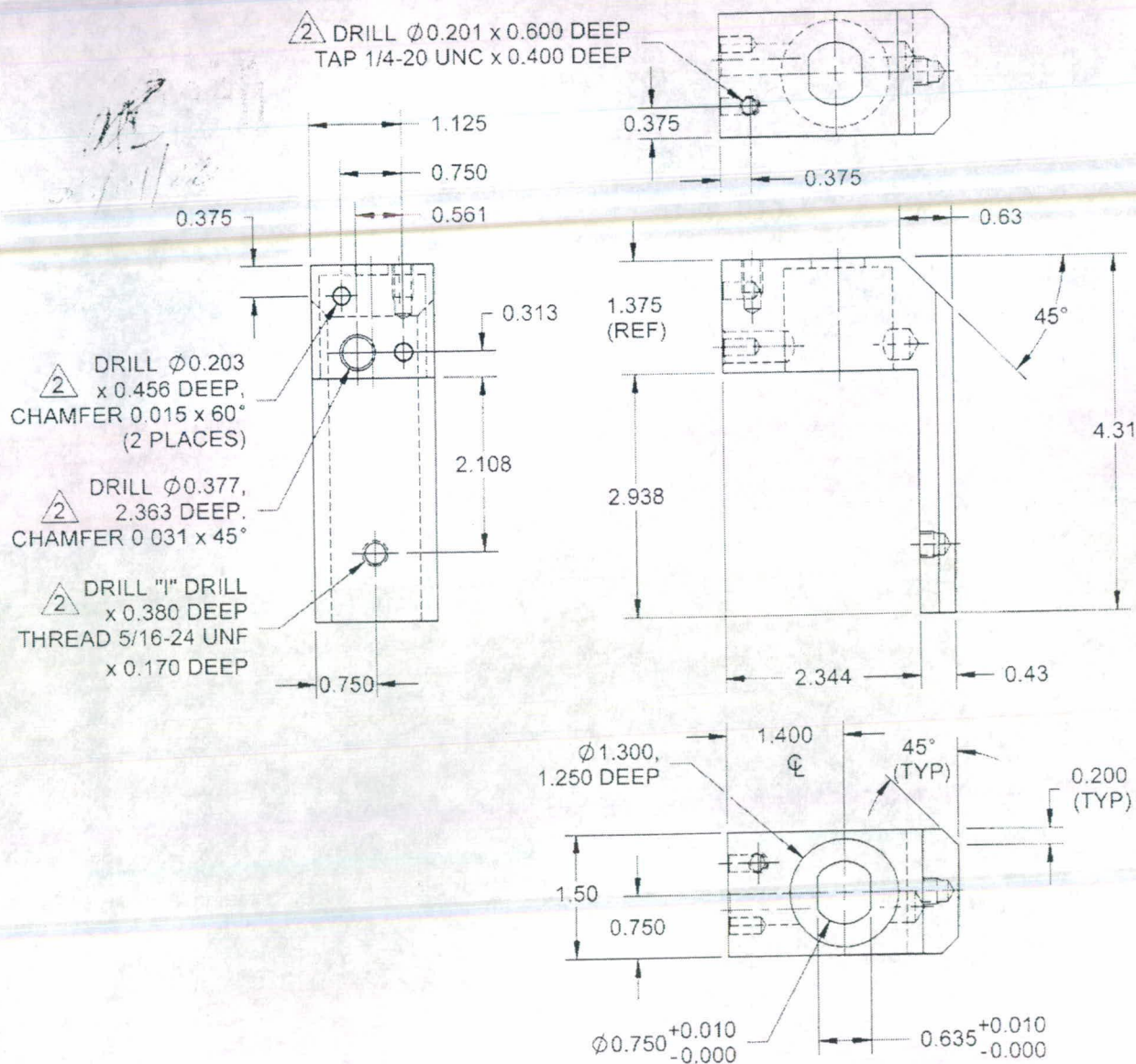
- 1) COVER DOWEL PIN (2 PLACES), D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 4 OF 6
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



D3400-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

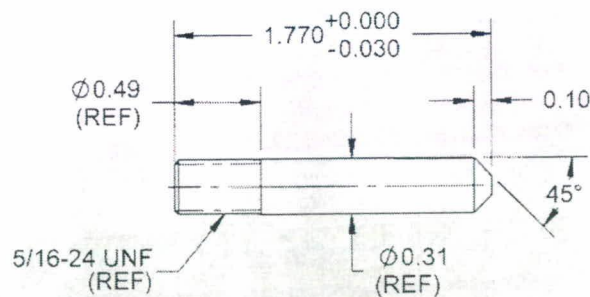
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. B SHEET 5 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING



D3400-3 GUIDE

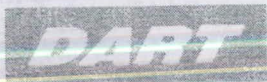
Handwritten: *all*
57994

NOTES:

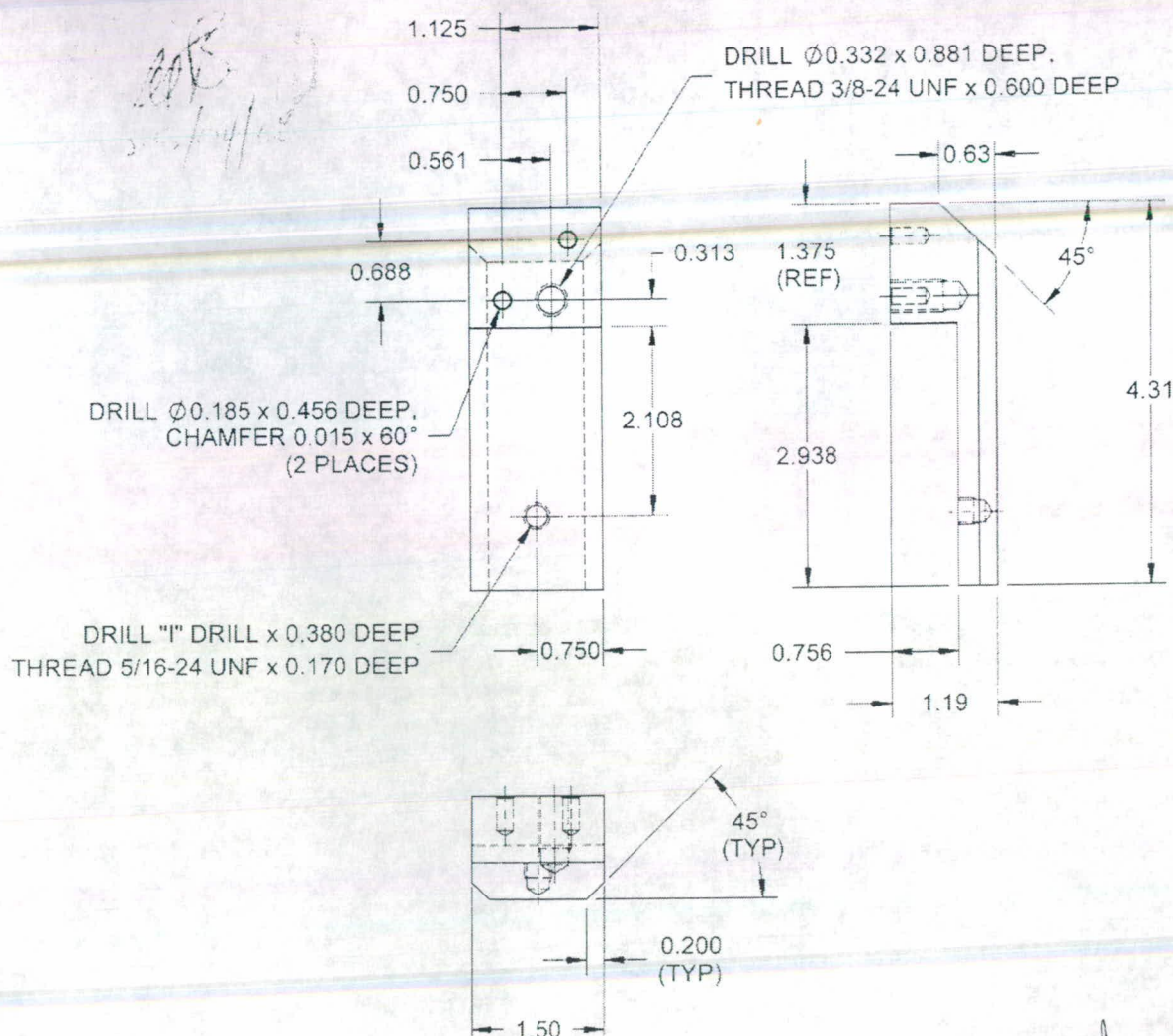
- 1) MATERIAL: AN5-17A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 6 OF 6
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



D3400-5 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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